

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009477**Date Inspected:** 07-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Xu Xian Ping	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG / Tower Subassemblies	

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #010 located on Traveller Rail - 11TR2-013. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

FCAW process welding of weld joint #014 located on Traveller Rail - 11TR2-013. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

FCAW process welding of weld joint #011 located on Floor Beam - FB3052-001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

FCAW process welding of weld joint #024 located on Floor Beam - FB3052-001. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

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FCAW process welding of weld joint #004 located on Floor Beam - FB3052-001. Welder is identified as 045276. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW process welding of weld joint #044 located on Floor Beam - FB3052-001. Welder is identified as 045276. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

FCAW process welding of weld joint #077 located on Floor Beam - FB3046-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

FCAW process welding of weld joint #078 located on Floor Beam - FB3046-001. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-TC-U4b-F.

SMAW process welding of weld joint #010B located on Tower Strut WD1-A305-53M-1. Welder is identified as 067707. ZPMC QC is identified as Xu Xian Ping. The welding variables recorded by QC appear to comply with the WPS-345-SMAW-2G(2F)-FCM-Repair.

### Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

### Traveller Rail

1. 10TR3-038-003,004
2. 10TR3-010-003,004
3. 10TR3-011-003,004
4. 10TR3-026-003,004
5. 10TR3-027-003,004
6. 10TR3-028-003,004
7. 10TR3-030-003,004
8. 10TR3-031-003,004
9. 10TR3-032-003,004

### Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

### Traveller Rail

1. 10TR3-033-003,004
2. 10TR3-034-003,004

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3. 10TR3-035-003,004
4. 10TR1-019-003,004
5. 10TR1-020-003,004
6. 10TR1-021-003,004
7. 10TR1-022-003,004
8. 10TR1-024-003,004
9. 10TR1-025-003,004

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Holmes,Stefan
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Hall,Steven
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QA Reviewer
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